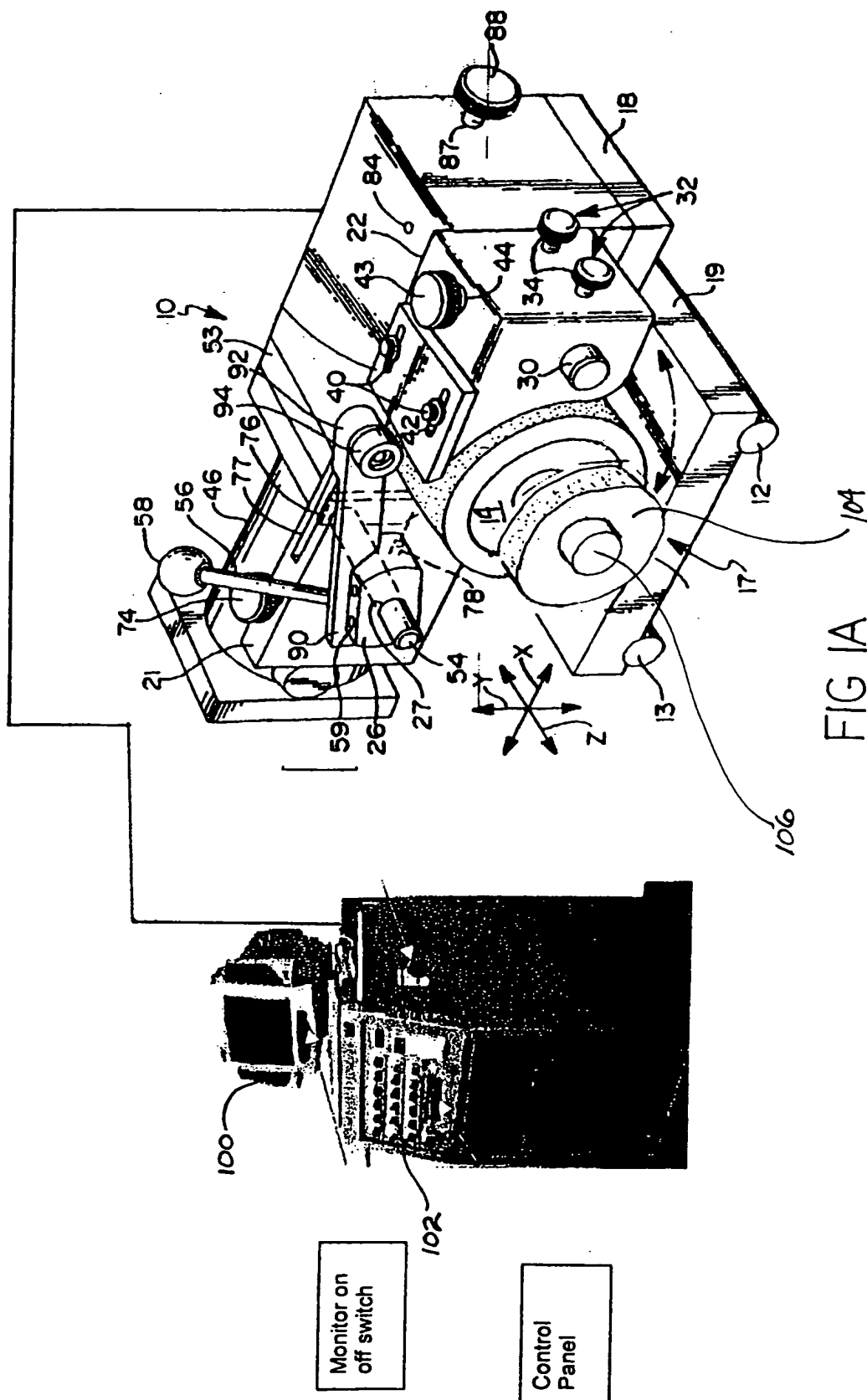


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5

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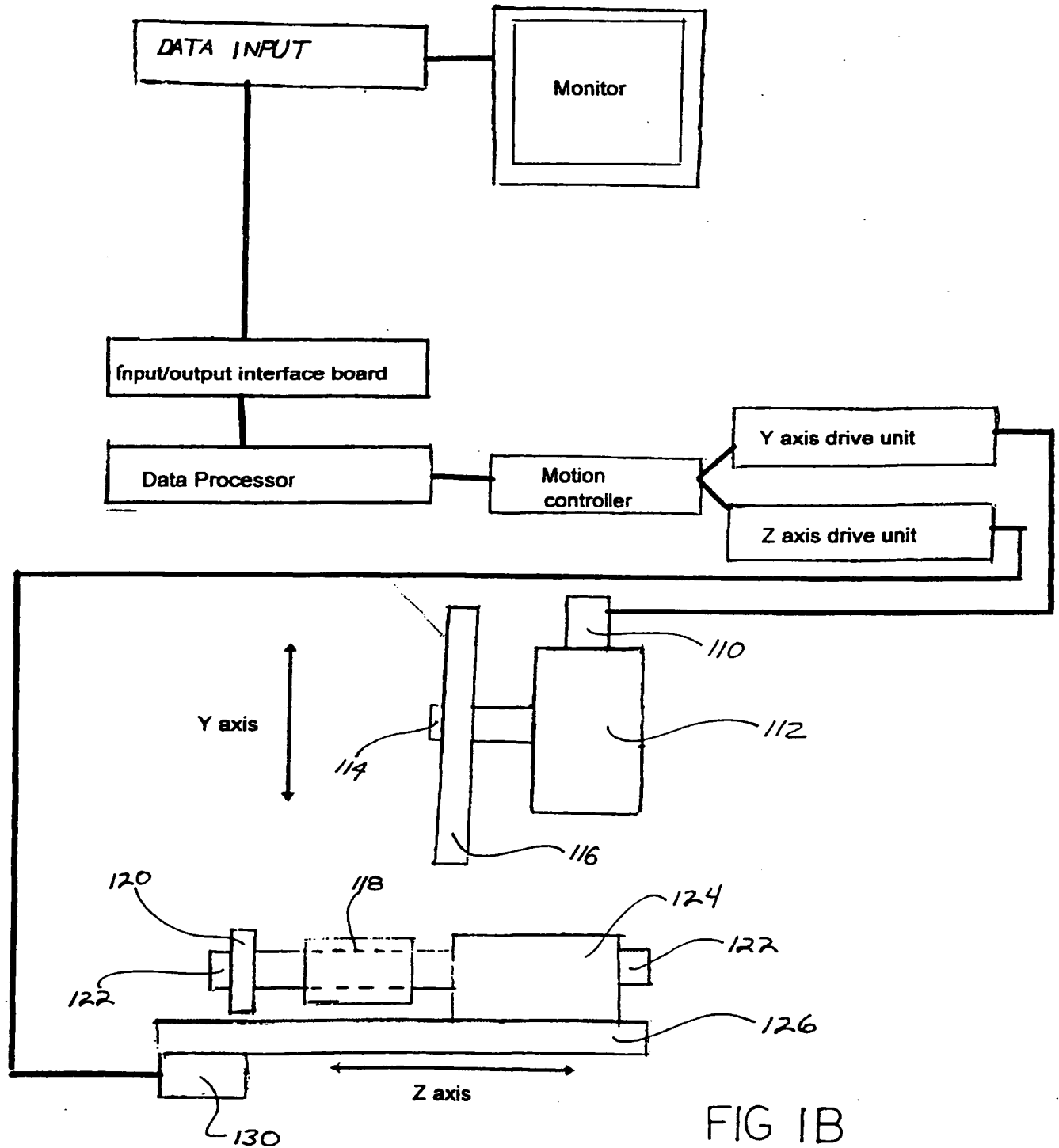
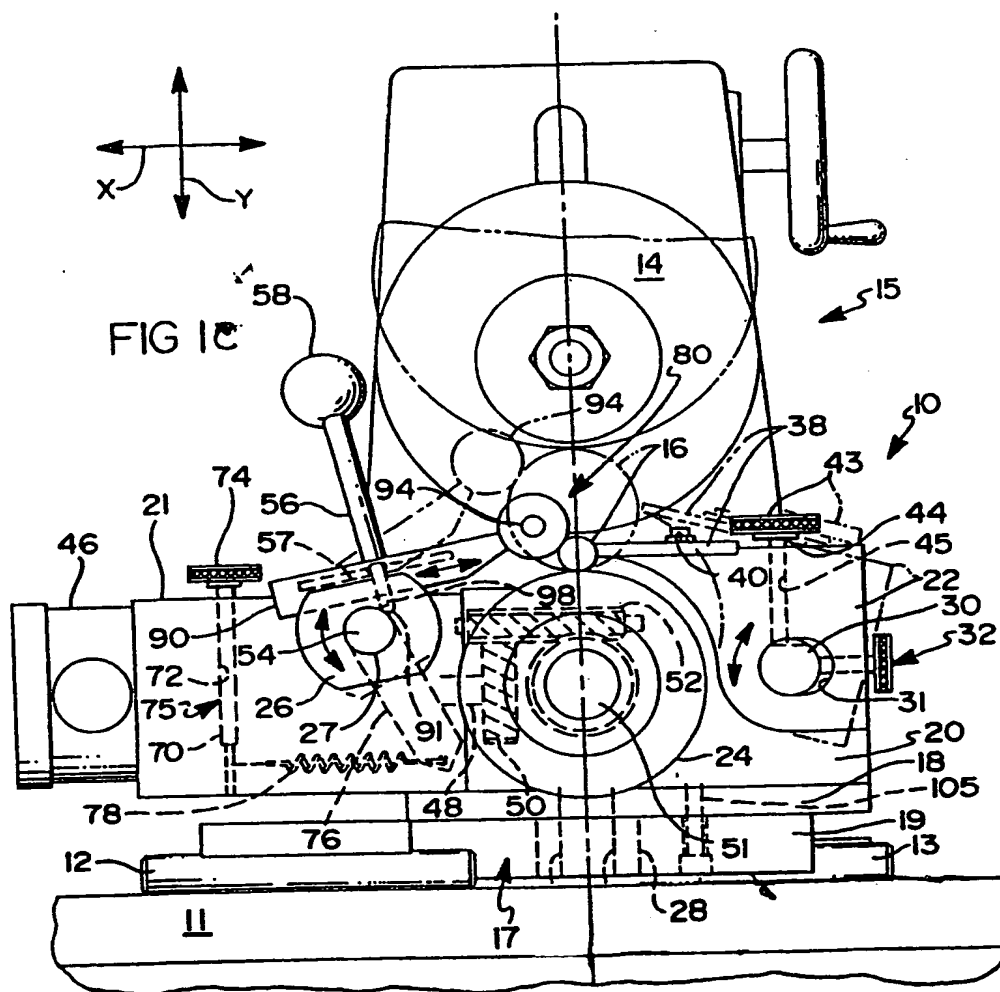


FIG 1B



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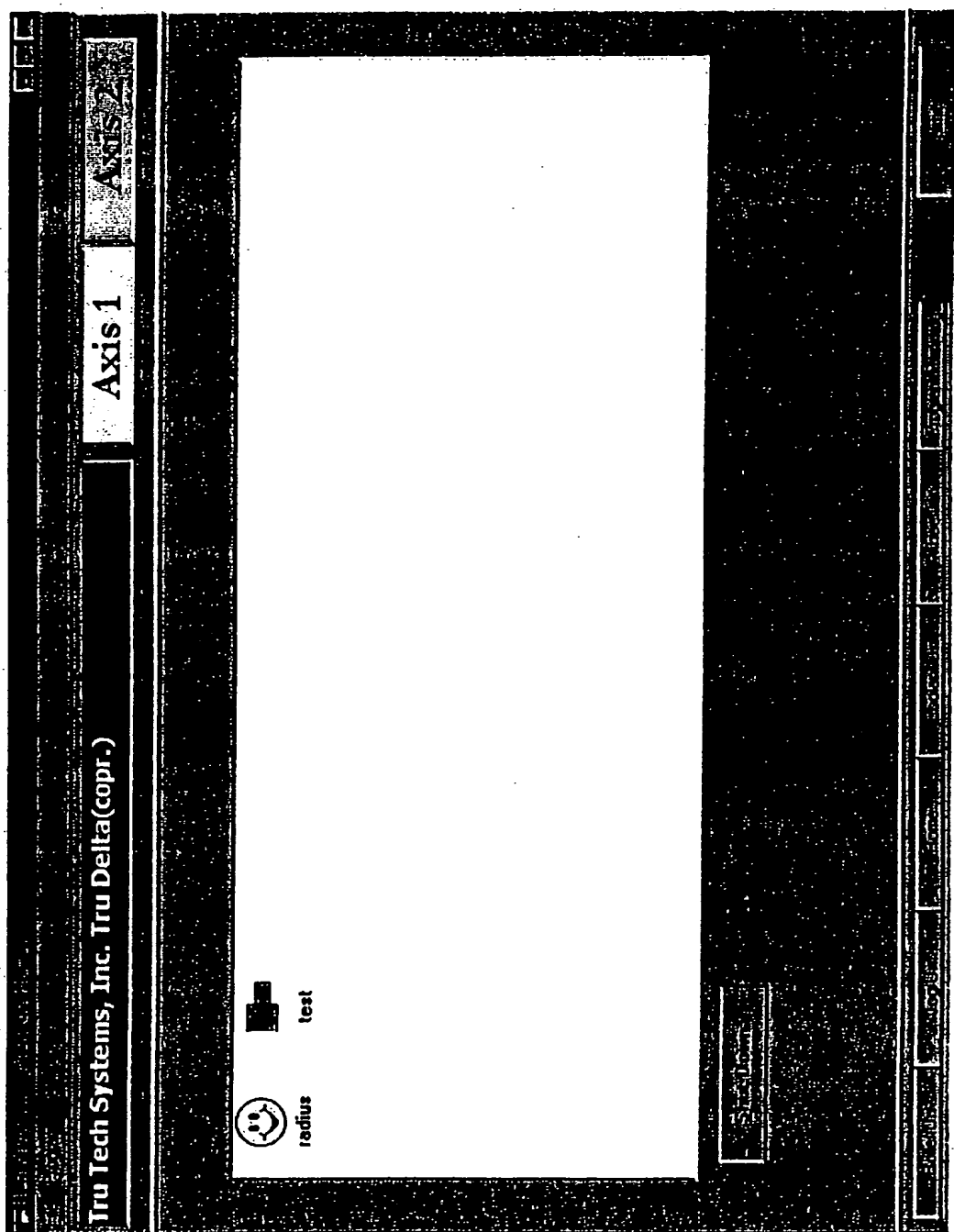


FIG 2

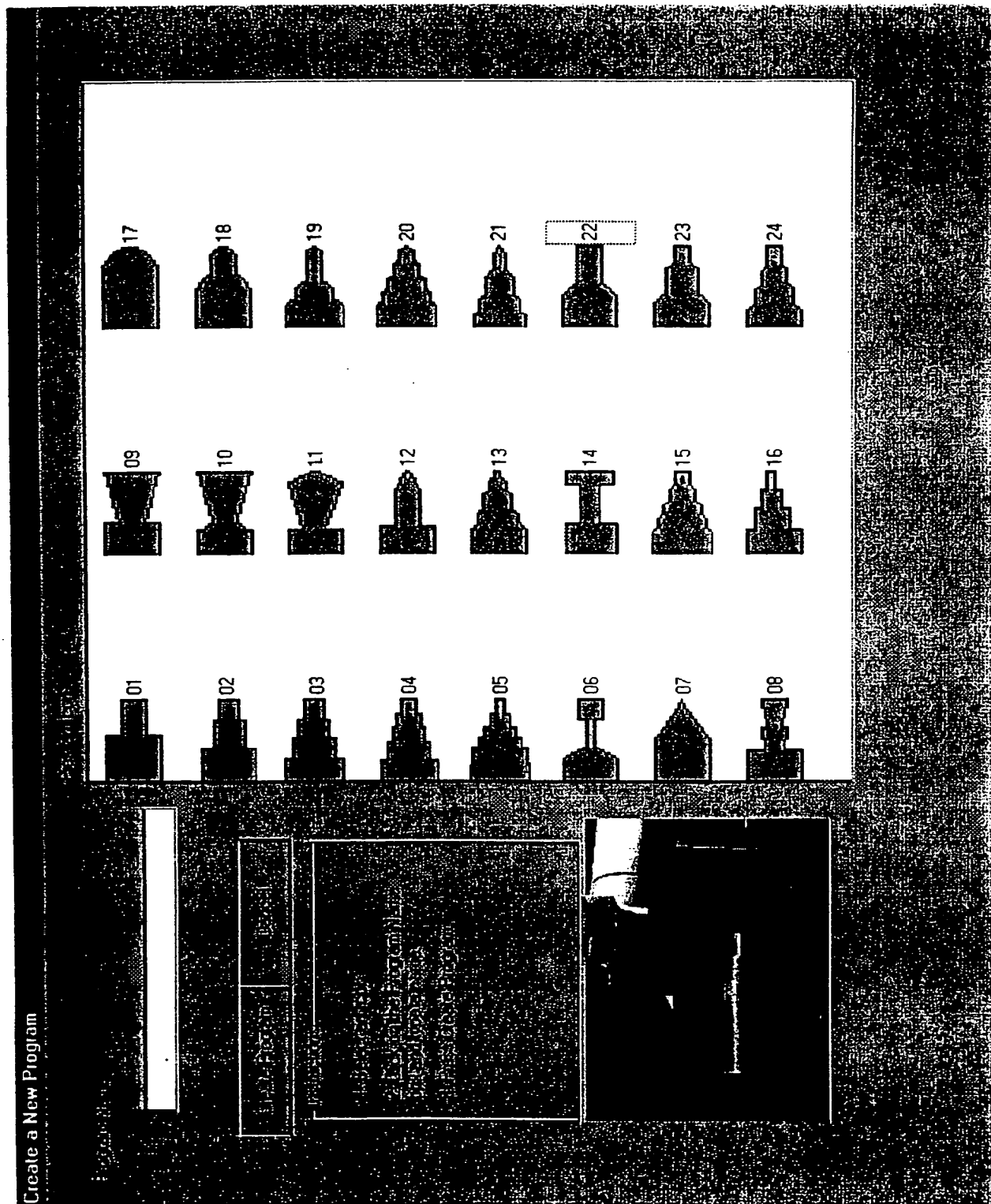


FIG 3

*Journal of Management Studies*, 19(1), 67-80.

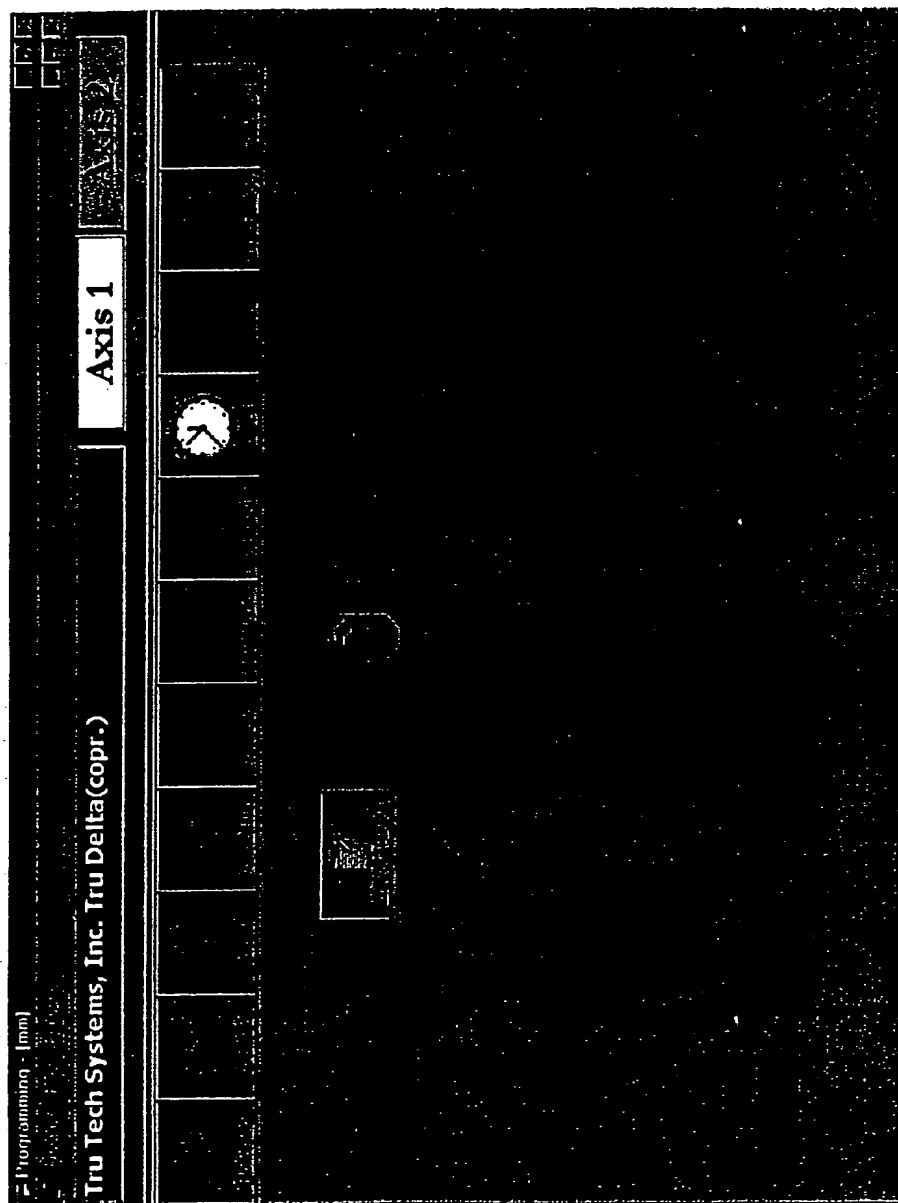


FIG 4



| Limits             |                     |                    |  |
|--------------------|---------------------|--------------------|--|
| Axis 1 Max. Travel |                     | Axis 2 Max. Travel |  |
| 00.40000           |                     |                    |  |
| Axis 1 Min. Travel | High Velocity Limit | Low Velocity Limit | Axis 2 Min. Travel   |
| 00.00000           | 20.00000            | 00.00000           |  |
|                    |                     |                    | <input type="button" value="OK"/><br><input type="button" value="Cancel"/> |

Fig 6

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Run Program (test)

Code Program Edit Program Offset Functions Goto Controls Edit Ver 4.6.6 ?

Tru Tech Systems, Inc. Tru Delta(copr.)

| Values Page 1   |                 | Values Page 2   |                 | Dress Routines  |                 |
|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|
| Axis 1 Position | Axis 1 Velocity | Axis 2 Position | Axis 2 Velocity | Axis 1 Position | Axis 2 Position |
| 00.00000        | 05.00000        |                 |                 |                 |                 |
| 00.00000        | 05.00000        |                 |                 |                 |                 |

Control Buttons

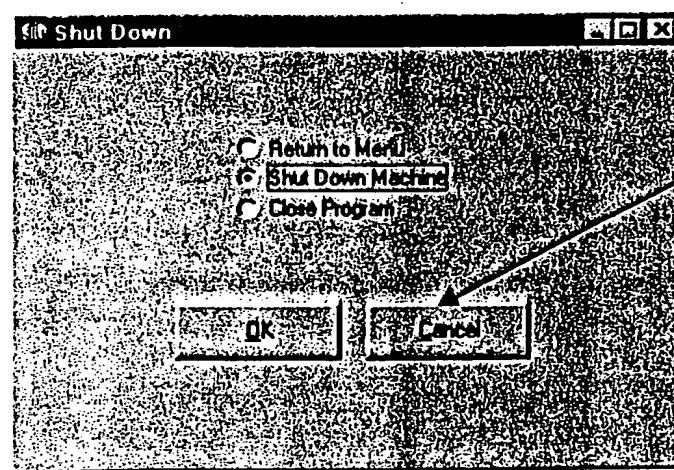
Page 2 Values

Dress routines

|              |        |        |            |          |                 |                 |            |           |
|--------------|--------|--------|------------|----------|-----------------|-----------------|------------|-----------|
| Send and Run | Offset | Offset | Stop       | Home     | coolant Off     | Jog is Disabled | Roller Off | Shut Down |
| Roll On      | Jog On | Home   | coolant On | Wheel On | Program Running | High Speed      | Units      |           |

Fig 7





Shut Down  
Menu

Fig 8

09/29/99 04:53:50

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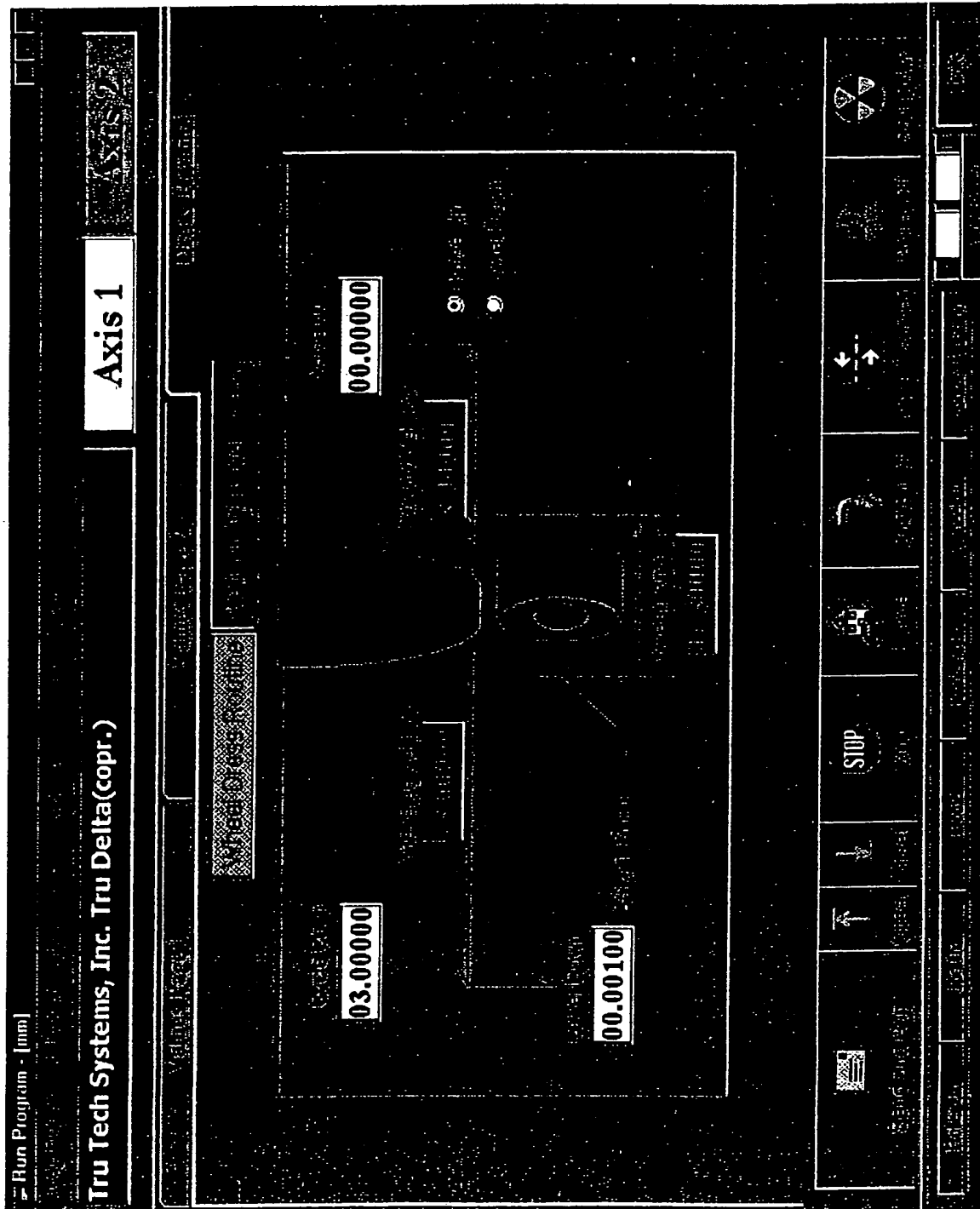
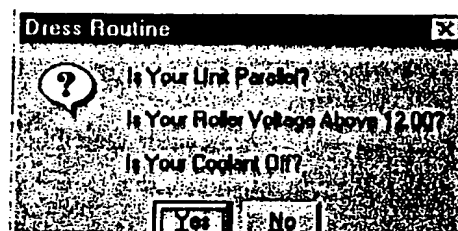


FIG 9

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FIG 10



09/23/99 08:50:50

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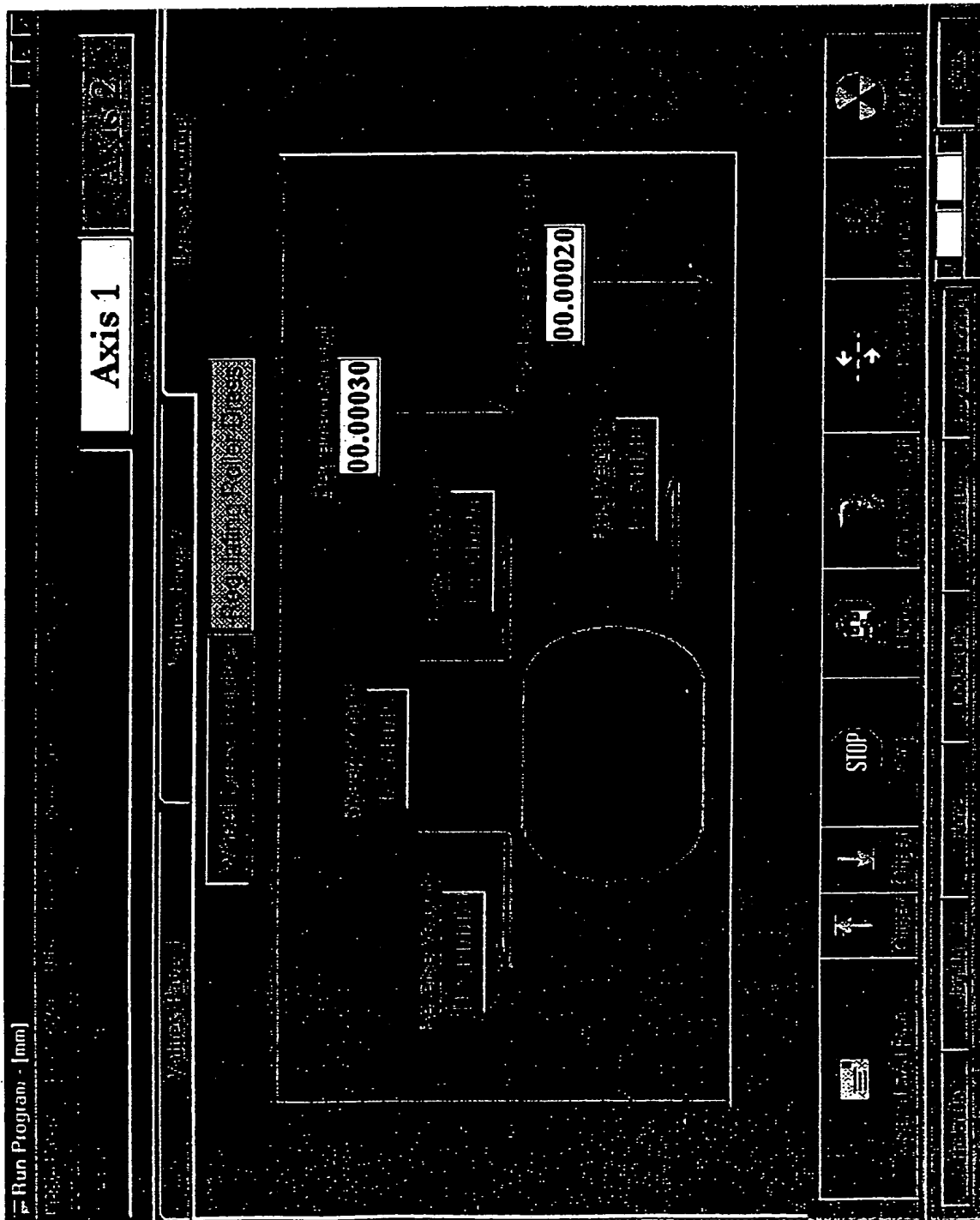


FIG 11

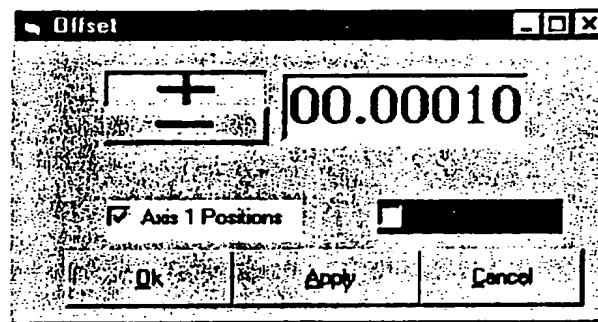


FIG 12

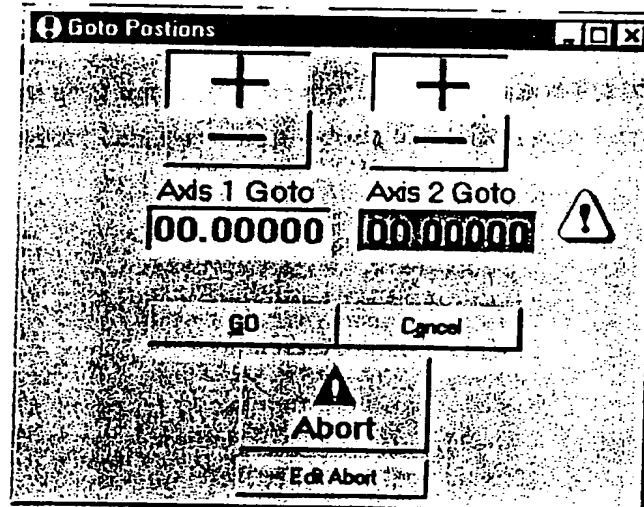


FIG 13

**Edit Abort**

|                           |                 |                 |                                 |
|---------------------------|-----------------|-----------------|---------------------------------|
| <div>+</div> <div>—</div> | Axis 1 Position | Axis 1 Velocity | <div>OK</div> <div>Cancel</div> |
|                           | 120.0000        | 05.00000        |                                 |
| <div>+</div> <div>—</div> | Axis 2 Position | Axis 2 Velocity |                                 |
|                           | 120.0000        | 05.00000        |                                 |

☐ Abort Axis 3 Position

FIG 14

**Menu [10m]**

Options Edit Functions

**System Aborted**

| Axis 1          |          | Axis 2          |            |
|-----------------|----------|-----------------|------------|
| Axis 1 Position |          | Axis 2 Position |            |
| Roll ON         | → ↓      | ↕               | → ←        |
| Roller On       | Axis 1 2 | Axis 1          | Axis 2 In  |
|                 |          | CCW Radius      | CW RADIUS  |
|                 |          | Dwell           | 1 sec      |
|                 |          | Loop Plunge     | Roller Off |

Shut off Roller and Return to Home

While Program

■ ■ ■ ■ ■ ■

FIG 15

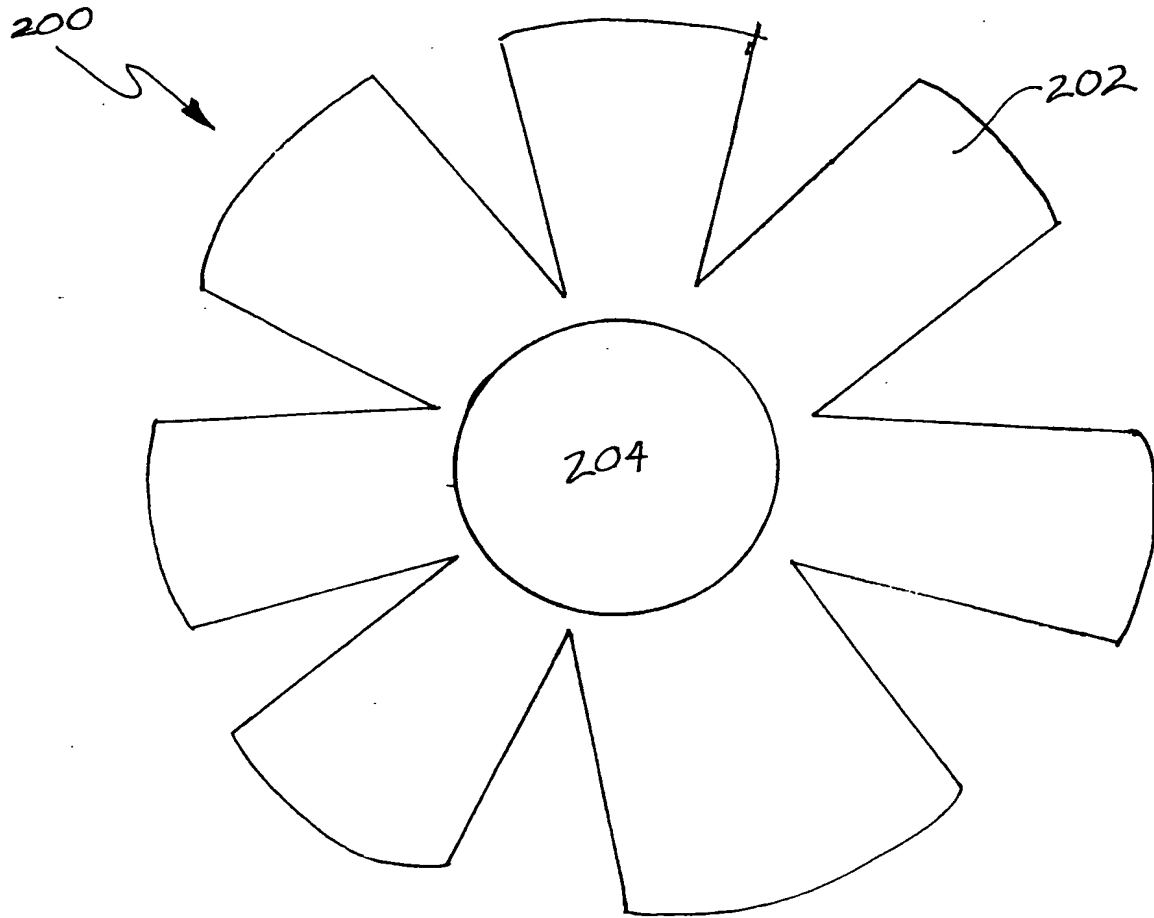


FIG 18

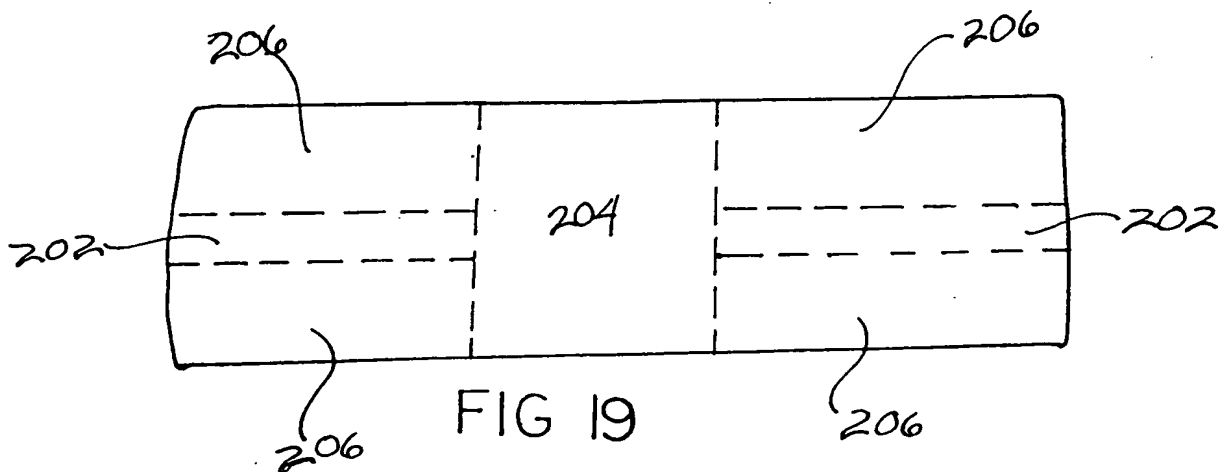


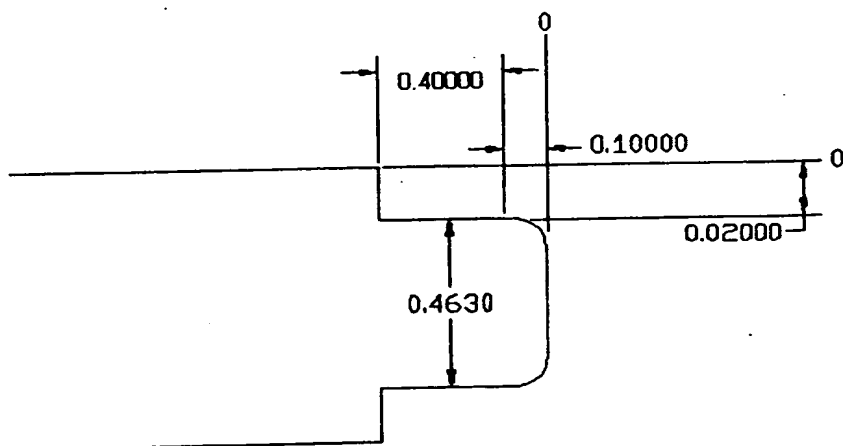
FIG 19

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| Axis 1 Positions | Axis 1 Velocities  | Radius       | Axis 2 Positions | Axis 2 Velocities  | Path Velocities |
|------------------|--------------------|--------------|------------------|--------------------|-----------------|
| Rapid Down To    | Velocity Down      | Radius Value | Rapid In To      | Velocity In        | Radius Velocity |
| 00.00000         | 05.00000           | 10.00000     | 10.00000         | 10.00000           | 10.00000        |
| Plunge To        | Velocity of Axis 1 |              | Move Out to      | Velocity of Axis 2 |                 |
| 00.02000         | 00.05000           |              | 10.00000         | 10.00000           |                 |

7. Next, enter the values as shown in figure Fig 16.

**Fig 16**



**Fig 17**

# RESEARCH



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